Monday, 1/14/2008 2:37:12 PM Date: User: Kim Johnston **Process Sheet Drawing Name** : STRAP Customer : CU-DAR001 Dart Helicopters Services Job Number : 36749B : 10729 **Estimate Number** Alh Part Number : D23245 P.O. Number S.O. No. : NA D2324 REV C : 1/14/2008 This Issue **Drawing Number** : N/A : NC Prsht Rev. Project Number First Issue Type : SMALL /MED FAB **Drawing Revision** :NA : 35930B Material Previous Run 40 Um: **Due Date** : 2/20/2008 Each Written By Checked & Approved By : Est. E 03.02.28 Reformat; Incorporated D2324-3 & D2324-5 K Comment J/RF **Additional Product** Job Number: Seq. #: Machine Or Operation: Description: 1.0 M304S16GA 304/316 .063 Sheet 1,488 Comment: Qty.: 0.7360 sf(s) 0.0184 sf(s)/Unit Total: 304/316 .063 Sheet 2.0 WATER JET Comment: FLOW WATER JET 1-Cut as per Dwg D2324 8-1-16 Dwg Rev: \_\_\_\_ Prog Rev: 2-Deburr if necessary 3.0 QC2 Comment: DIMENSIONAL CHECK Inspect dimensions per template D2324-5T1 4.0 QC8 SECOND CHECK Comment: SECOND CHECK 5.0 SMALL FAB SMALL & MEDIUM FAB RESOURCE Comment: SMALL & MEDIUM FAB RESOURCE Debunt necessary

## **Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES								
DATE	STEP	PROCEDURE CHANGE	PROCEDURE CHANGE			Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
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Part No:	PAR #:	_ Fault Category: _	 NCR: Yes No	DQA:	Date: 08/01/17
			QA: N/C C	losed:	Date:

NCR:		WORK ORDER NON-CONFORMANCE (NCR)									
		Description of NC		Corrective Action Section E	Verification	Annaval	Approval				
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	QC Inspector			
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NOTE: Date & initial all entries

Date: Monday, 1/14/2008 2:37:12 PM User: Kim Johnston **Process Sheet** Customer: CU-DAR001 Dart Helicopters Services **Drawing Name: STRAP** Job Number: 36749B Part Number: D23245 Job Number: Seq. #: Machine Or Operation: Description: PACKAGING 1 PACKAGING RESOURCE #1 6.0 Comment: PACKAGING RESOURCE #1 Identify and Stock Location:\_ 7.0 QC21 FINAL INSPECTION/W/O RELEASE Comment: FINAL INSPECTION/W/O RELEASE u 08/01/17 Job Completion

Dart Ae	rospace	e Ltd								+	
W/O:				٧	VORK ORDER CH	ANGES	,				
DATE	STEP		PROCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
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Part No	•		PAR #:	Fault Ca	tegory:	NC	R: Yes	No DQ	A:	Date: _	
							QA: N	/C Close	d:	Date: _	
NCR:			V	VORK OR	DER NON-CONFO	RMANCE	(NCR	)			
		Description of NC	Description of NC	Corrective Action Section B		Section B		Verific	cation	Approval	Approval
DATE	STEP		Section A	Initial Chief Eng	Action Descrip Chief Eng	otion	Sign & Date	Secti		Chief Eng	QC Inspector
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)									
		Description of NC		Corrective Action Section B		Verification	A 1	Approval			
DATE	STEP	Section A			Sign & Date	Section C	Approval Chief Eng	Approval QC Inspecto			
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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	36749B
Description: Strut	Part Number:	D2324-5
Inspection Dwg: D2324 Rev: C		Page 1 of 1

	FIRS	T ARTICLE II	NSPECTION	ои сн	ECKLIST		
		First Arti	cle	Pro	totype		
Drawing Dimension	Tolerance	Actual Dimension	Accept	Rejec	t Method of Inspection	С	omments
R0.38	+/-0.030						
Ø0.257	+0.006/-0.001	, 258	X				1
Ø0.191	+0.005/-0.001	.193	×				
0.750	+/-0.010	743	87				
0.375	+/-0.010	373	¥				
1.875	+/-0.010	1.875	×				
3.000	+/-0.010	3,000					
3.375	+/-0.010	3.373	×				
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Measured by:		Audited by:	9		Prototype Appr		N/A
Date:	8-1-16	Date:	0810	1/16		Date:	N/A

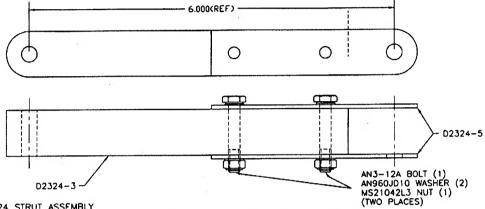
Rev	Date	Change	Revised by	Approved
Α	06.06.05	New Issue	KJ/JLM	
				_, ,



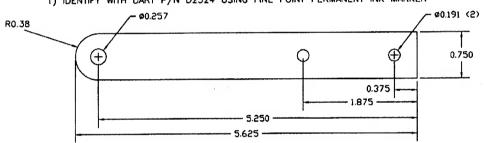
DESIGN B W	i ILLIAMS	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECK		APPROVED.	DRAWING NO.	REV. C
	#	#	D2324 SHEET	1 OF 1
DATE			TITLE	SCALE
04.1	2.14		STRUT	
Α		94.11.08	NEW ISSUE	
R		96.05.07	UPDATE MATERIALS	

RELEASED 04.12.16

UPDATE NOTES C 04.12.14



D2324 STRUT ASSEMBLY 1) IDENTIFY WITH DART P/N 02324 USING FINE POINT PERMANENT INK MARKER



D2324-3 1) MATERIAL: 6061-T6/T651 BAR (QQ-A-200/8) 0.75 X 0.75

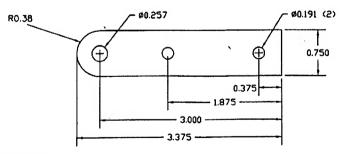
(REF DART SPEC. M6061T6B0.750X00.750)

ACID ETCH AND ALODINE PER DART QSI 005 4.1 2) FINISH:

POWDERCOAT WHITE (4.3.5.1) PER DART QSI 005 4.3 3) BREAK ALL SHARP EDGES 0.005 TO 0.015

4) ALL DIMENSIONS ARE IN INCHES

5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



D2324-5

AISI 304/316 STAINLESS STEEL SHEET 16 GAUGE (0.063 THICK) 1) MATERIAL: (REF DART SPEC. M304S16GA)

2) FINISH: POWDERCOAT WHITE (4.3.5.1) PER DART QSI 005 4.3

3) BREAK ALL SHARP EDGES 0.005 TO 0.015

4) ALL DIMENSIONS ARE IN INCHES

5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY RETURN TO ENGINEERING UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE

WORK ORDER 9B